

Date: Monday, 2/27/2006 4:08:44 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP WELDMENT		
Job Number	: 25944A					
Estimate Number	: 10176					
P.O. Number	: N/A			Part Number	: D2563	
This Issue	: 2/27/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2563 REV C	
First Issue	: N/A		Type	: LARGE FAB ASSY		
Previous Run	: 25943A			Project Number	: N/A	
Written By	: <u>See comment below</u>			Drawing Revision	: C	
Checked & Approved By	: <u>TD</u> 06.02.28			Material	: N/A	
Comment	: Est Rev:G 02.07.31 Re-format Location RF			Due Date	: 3/30/2006	
				Qty:	10	Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2244116 Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: 20452 = 6 B23404 = 4

KE 06.04.05 10

2.0 D267334 End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part No. Description

2 D2673-34 End Cap

Batch

325396

KE 06.04.05 10

3.0 D2561 Lug Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part No. Description

2 D2561 Lug Plate

Batch

325968

KE 06.04.05 10

4.0 D2564 Mounting Angle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part No. Description

2 D2564 Mounting Angle

Batch

324496 = 6

KE 06.04.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:08:44 PM
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Drawing Name: STEP WELDMENT

Job Number: 25944A

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

KE 06.04.05 10

2-Deburr ends

KE 06.04.05 10

3-Weld (1 End Only) as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M18838

KE 06.04.08 10

4-Grind

FF 06.04.10 10

6.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06.04.12

10

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06.04.16 10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PR 06.04.17 10

9.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

KE 06.04.17 10

2-Weld Remaining End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M18838

KE 06.04.17 10

3-Grind

FF 06.04.19 10

10.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06.04.19 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:08:44 PM
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Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Touch up Alodine then *a.m. 06-04-20* (10)

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

a.m. 06-04-21 (10)

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1-4/29 (10)

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

10/04/26 (10)

Job Completion



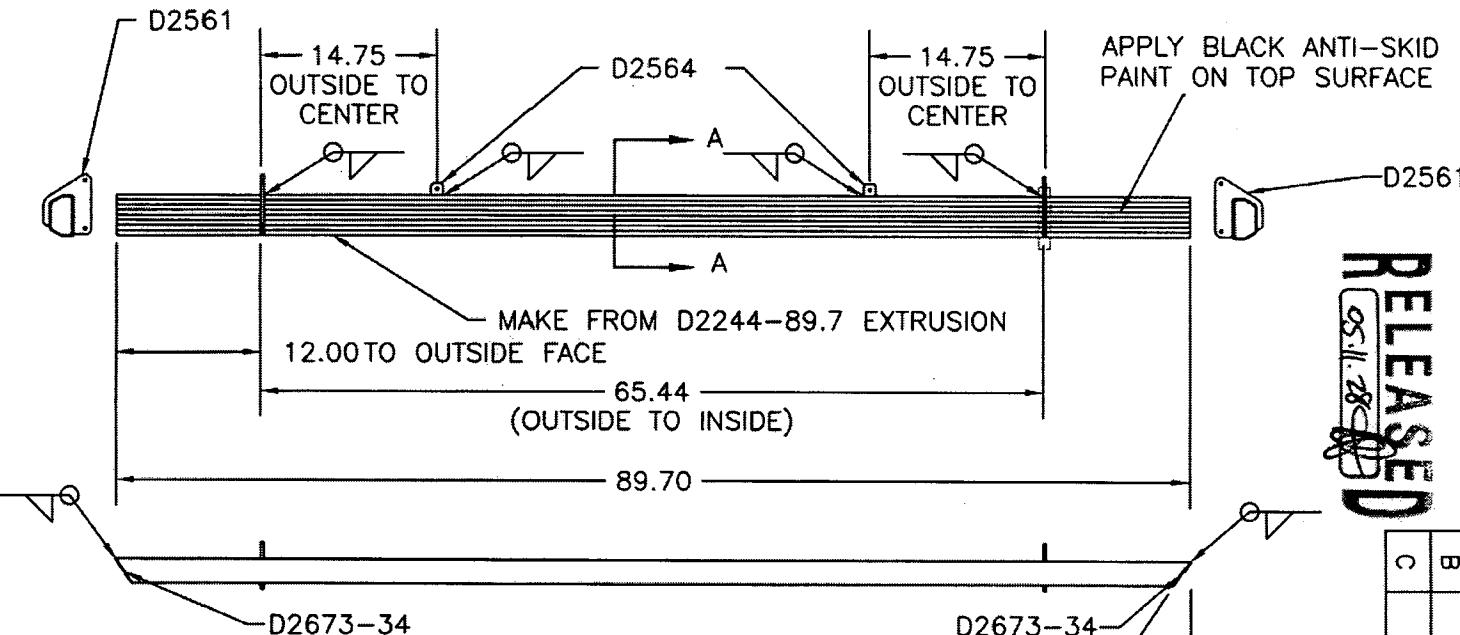
10/04/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

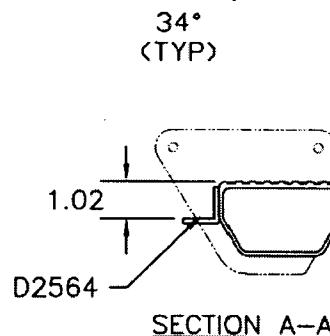
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
*05.11.28.00***D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

**D2563 STEP WELDMENT ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25944A

SHOP COPY
RETURN TO
ENGINEERING

DESIGN BW	DRAWN BY	DART AEROSPACE LTD
	44	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	TITLE
		D2563
DATE		SCALE
05.11.14		1:15
A	96.04.26	NEW ISSUE
		END CAPS CHANGED (WAS D2248)
B	97.05.14	
C	05.11.14	UPDATE NOTES